

Work Order ID 127605

December-17-14 1:40:04 PM

127605

Page 1

Item ID: D3821-1KGY

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel W/O Rotor Brake-Grey

Start Date: 12/12/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-12-23

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3821-1	Rev. B
---------	--------

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

DAS

07

9-89

xl15/01/07

105

0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

DAS

07

9-89

xl15/01/07Temp: 150 deg F

JAN 27 2015

Time IN: 5:00 PMTime OUT: 6:00 AM

Per.....

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Start Date: 12/12/14 Start Qty: 1.00

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Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							07 9-89

110

Thermoform

Thermoforming Machine

Memo

0.00

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA023 using tool DT9053

Dwg Rev: BFolio Rev: B

Visually inspect for proper formation of each part

X115/01/27

140

0.00

140

HandThermo

Hand Finishing Thermoforming

Memo

0.00

1-Trim to finished dimensions as per Dwg

X115/01/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling									
Handling/Pre									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Required Date: 12/17/14 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
150									
QC	Memo	0.00							
Quality Control	Complete FAI document								15/01/27
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							DA8 38 9-88
Quality Control									
170	Identify as per dwg & Stock Location: PK 616	0.00							
170									
Packaging	Memo	0.00							DA 88 9-88
Packaging									

FEB 02 2015

FEB 04 2015

DA8
98
9-88

DQA: _____ Date: _____



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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127605

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Page 4

Item ID: D3821-1KGY

Accept

N900040100Setup Start ***NS1***

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1

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 1502-05

15.2-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

December-17-14 1:40:04 PM

Page 1

Work Order ID: 127605

127605

Parent Item: D3821-1KGY

D3821-1KGY

Parent Item Name: Panel W/O Rotor Brake-Grey

Start Date: 12/12/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

Ipp Rev. A New Issue DL

Ipp Rev. B Add Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased		No		100	sf	3,547.130	12.79	13			

MKYD6185S 080-P3-52068

Kydex steel grey (52"x96"-.080)

DAS
07
9-69

15/01/27

Location

Loc Qty

Loc Code

LAIRD

2011.6

m129546

347

m129760

1178.6

m130383

486

therm

2368.53

119476

51.53

121902

620

122181

1003

m127759

347

m128321

347

13 sq ft.

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order: 127605
Description: Panel, without Rotor Brake		Part Number: D3821-1KIV/KGY
Inspection Dwg: D3821	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 15/01/27

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	Min	1.04	✓		DL-02	
0.75	Min	.768	✓		DL-02	
0.63	Min	.680	✓		DL-02	
0.25	Min	.282	✓		DL-02	
0.375	Min	.411	✓		DL-02	

Measured by: JB

Date: 15/01/27

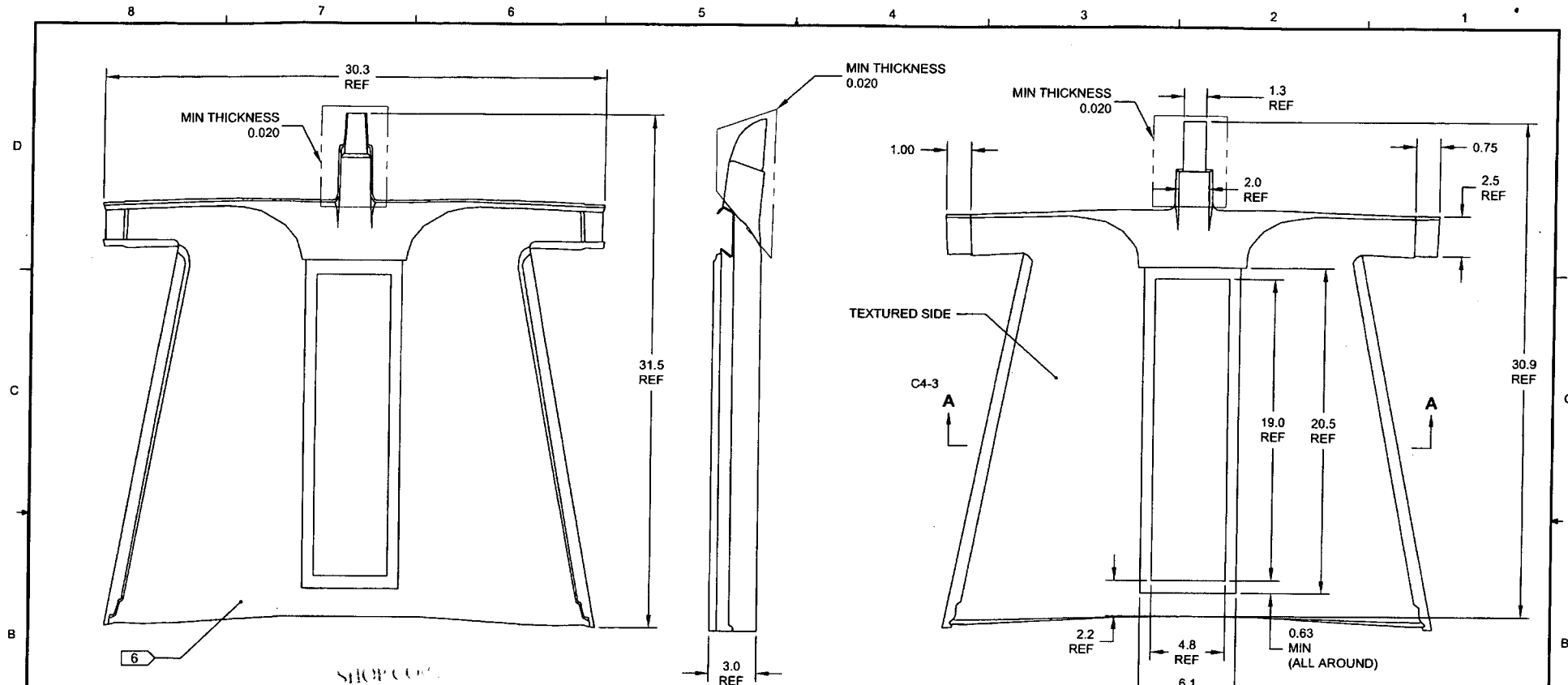
Audited by: 38

Date: FEB 02 2015

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ <u>JB</u>	<u>JB</u>



SHOP COPY
 RETURN TO
 PARTS
 UNCONTROL LTD COY
 127605 MJS
 14-12-23

D3821-1 PANEL, WITHOUT ROTOR BRAKE
 (BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9053 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

B
 B

PART NUMBER	DESCRIPTION
D3821-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3821-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

B	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3821-1KIV, D3821-3KIV AND ADD STEEL GRAY P/N'S D3821-1KGY, D3821-3KGY (ZN A5-1, A5-2)	PH	09.05.05
A	NEW ISSUE	PH	08.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3821
 REV. B
 SHEET 1 OF 4
 SCALE
 NTS

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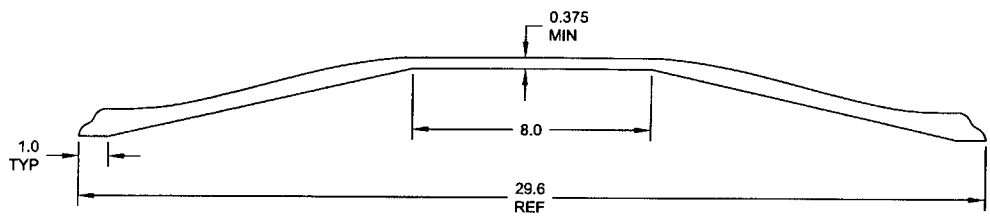
RELEASED
 8/05/22 MB

VIEW C B4-3

SECTION A-A C4-1



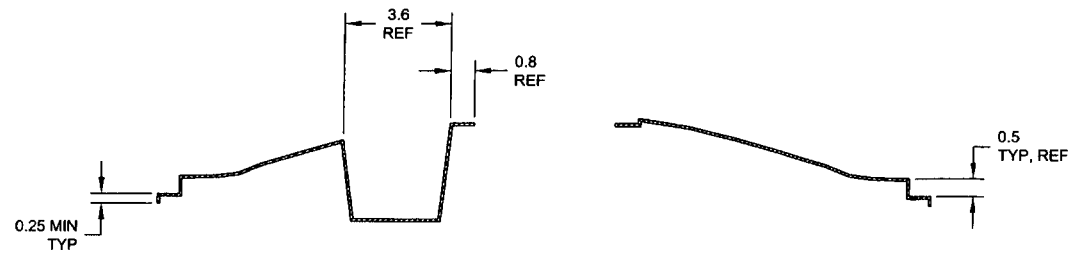
VIEW C A2-1



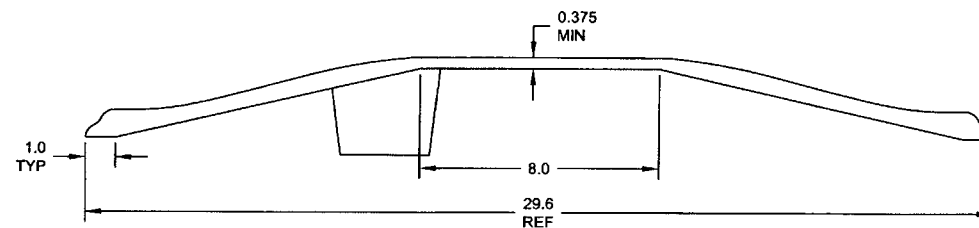
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